

Date: Wednesday, 2/8/2006 1:22:55 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BACK  
 Job Number : 25744  
 Estimate Number : 10879  
 P.O. Number : N/A Part Number : D32501  
 This Issue : 2/8/2006 S.O. No. : N/A Drawing Number : D3250 REV B C 06.02.08  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 25724 Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 2/28/2006 Qty: 20 Um: Each  
 Checked & Approved By :  
 Comment : Est. B 04:10:26 D3250-1 no longer made in-house

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O

Fabricate D3250-1 as per Dwg D3250

Possible supplier: Industrial Laser

Material release note is required

u 06.02.08

2.0 D32501B Back



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 Back

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

P 6/4/6

20

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

20 06.04.06

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

H.M 06/05/08

20

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 1:22:55 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK

Job Number: 25744

Part Number: D32501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*J 05-09 (20)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*H.M 06/05/09 20*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*PC 06 05 15 20*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*06/07 17 20*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 135*

*06/05/17 (20)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/05/18 (20)*

Job Completion



*U 06.05.18*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Quotation

#7 - 7504 Vantage Place

Delta, B.C. V4G 1A5

PH: (604) 946-4152

FAX: (604) 946-4153

EMAIL: jeff@industrialallaser.com

Date: 08-Feb-06

Company: DART AEROSPACE

To: LINDA LACELLE

From: JEFF MOSTAT

Quote No.: DA-020806-01

Part No: AS SHOWN

Quantity	PART DESCRIPTION	Cut Charge	Form Charge	Material Charge.	Part Charge.		Lot Charge
20	D3249-C1	\$22.00	\$2.00		\$24.00	ea.	\$480.00
20	D3250-C1	\$32.00	\$2.00		\$34.00	ea.	\$680.00
	material (on Dart Acct.)						
	*4 sheets 4' x 12' 2024 T3						
4	Bare (2 weeks delivery)			\$392.00		ea.	\$1,568.00
4	Alclad (available now)			\$444.00		ea.	\$1,776.00
	(Copper&Brass supplies)						
	*nesting utilizes 3.5 sheets						

TOTAL CHARGE THIS QUOTATION: n/a

G.S.T.: n/a

P.S.T (IF APPLICABLE): n/a

TOTAL ORDER CHARGE: n/a

### TERMS AND CONDITION.

Prices good for 10 days.

F.O.B. our plant, taxes out

Terms: net 30 days with account, COD without

### LEAD TIME (WORKING DAYS):

Please complete order information below and fax return to I.L.C.

P.O. Number:

Date:

P.S.T. No.:

Signature:

257081

06-04-06

# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Per:

*Mark J. Vrablec*

Mark J. Vrablec  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

525383  
Ship Date

2005-11-07

P.O. No./Govt Contract No.

CG1887

306094

B.L. No.

87255

Invoice No.

42246

Customer

C&B-WHS-SCHAUMBERG

Alcoa No. Item

DS-90097-1

Page 1

Ship To: COPPER & BRASS SALES, INC.  
415 STATE PARKWAY  
SCHAUMBURG, IL 60195

## Item Description

.0630 IN TK X 48.000 IN W X 144.000 IN LN CAT D 126153 (N) A/T 2024-  
T3 FLAT SHEET MILL FINISH {{ P/N 061847-0 }}. PER AMS-QQ-A-  
250/4 REV A & (EXCEPT OIL &  
MARKING) AMS4037 REV N & (EXCEPT MARKING)  
ASTMB209 REV 04 ((MARKED)) INTERLEAVED SKID  
WGT: 4500 LB QUAN TOL +/-10 %  
CQR D126153 REV 28 QRR 003140 CUST REQ 05-11-  
06 \*\*\* W/E 05-11-12 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	306626	481111	3851	90	PC	

Notes for CQR: D126153.28

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/4 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/4E, AMENDMENT 2.  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/4E AMENDMENT 2 ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/4.

CQR: D126153.28 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T3	Long Transv.			63.0	42.0	15

Chemical Composition	Max	SI	FE	CU	MN	MG	CR	ZN	TI	Each	Total	Aluminum
Alloy 2024		.50	.50	4.9	.9	1.8	.10	.25	.15	.05	.15	
	Min			3.8	.30	1.2						REMAIN

Lot: 481111 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No. Test	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T3	Long Transv.	6			68.4	45.5	20.5
					67.5	44.9	17.5

*1644-06*

# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

PITTSBURGH, PA

DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Per:

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

525383

Ship Date

2005-11-07

P.O. No./Govt Contract No.

CG1887

306094

B.L. No.

87255

Invoice No.

42246

Customer

C&B-WHS-SCHAUMBERG

Alcoa No. Item

DS-90097-1

Page 0

TOTAL COPIES: 2. WITH SHIPMENT

COPPER AND BRASS SALES  
22355 WEST ELEVEN MILE RD  
SOUTHFIELD, MI 48034

COPPER & BRASS SALES, INC.  
415 STATE PARKWAY  
SCHAUMBURG, IL 60195

# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Per:

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Davenport Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

525383  
Ship Date

2005-11-07

P.O. No./Govt Contract No.

CG1887

306094  
B.L. No.

87255

Invoice No.

42246

Customer

C&B-WHS-SCHAUMBERG

Alcoa No. Item

DS-90097-1

Page 2

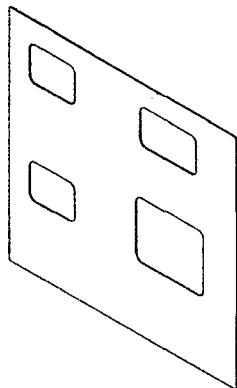
Lot: 481111 - Mechanical, Physical, Metallograpy, Quantometer Results (cont.) -----

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9214012	Actuals	.07	.14	4.6	.63	1.6	.00	.06	.03

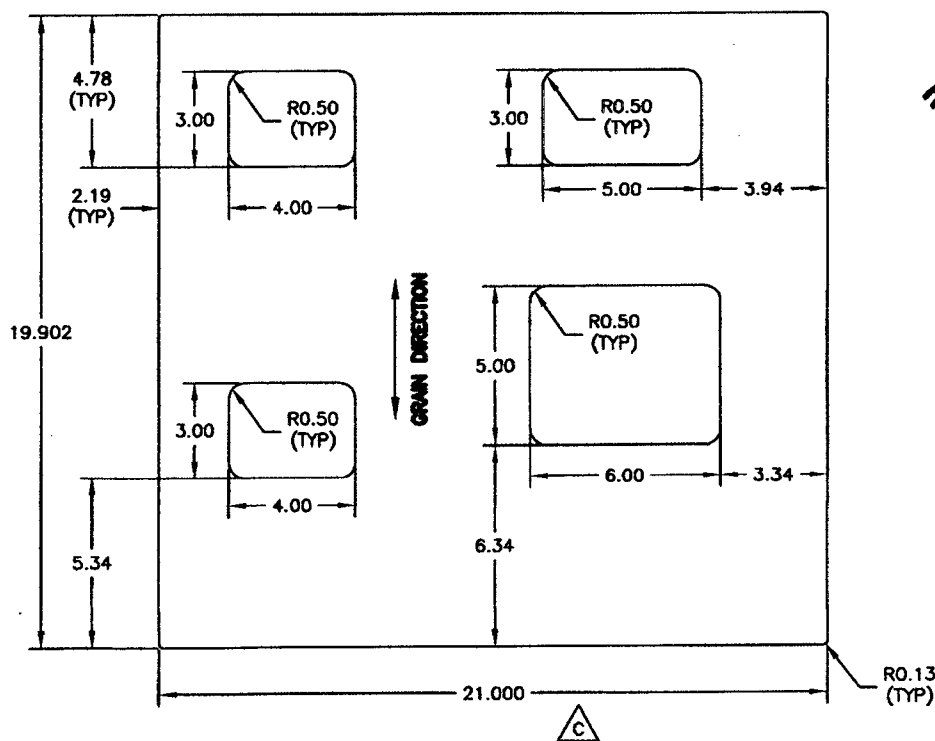




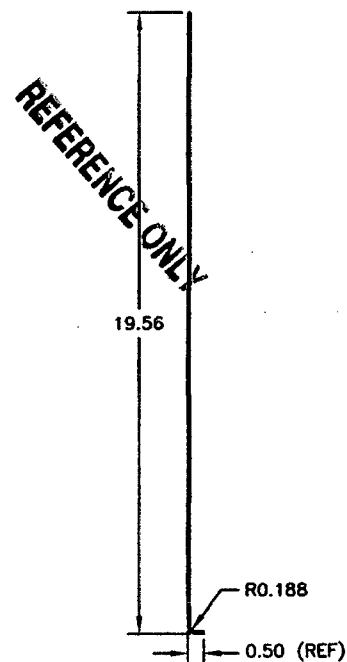
DESIGN RF	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3250	REV. C SHEET 1 OF 1
DATE 06.02.01		TITLE BACK (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.243	
C	06.02.01	21.000 WAS 20.625, REMOVE $\phi 0.501$ TOOLING HOLES	



RELEASED  
06.02.13 H



**D3250-1F FLAT PATTERN**



**D3250-1 BEND DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.